January-10-13 11:04:36 AM Item ID: D3219-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Plate **Start Date:** 1/10/13 **Start Oty:** 60.00 Cust Item ID: Required Date: 1/17/13 Reg'd Otv: 60.00 Customer: Reference: Run Process Plan: MLJ Date: 13-01-10 Tooling: **Approvals:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** D3219 Rev A 100 0.00 FLOW WATER JET *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3219 Dwg Rev: 6061,125. Prog Rev: 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* OC 0.00 Memo **Ouality Control** 120 QC8- Inspect parts - second check QC Memo Quality Control

										DQA:	Date:	
NCR:	res / No				WORK ORDER NON-C	CON	FORM	MANCE / UP	DATE	QA Closed:	Data	
				-						QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No		Scrap Ma Use-as-is Thermof Work Order Update La			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root	·			Descri	ption of work order update	In	itial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											·	
					F	AULT	CATE	GCIRY		· · · · · · · · · · · · · · · · · · ·		
Landir	ng Gear				General					-		-
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	Crimped it n Strip in		O/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		nstruct	on Incomplete ions Incomplete/I nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Torque W	aves in E	xtrusio	ń 📙	Drawing	П	Out of C	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

150

150 Packaging

Packaging

January-10-13 11:04:36 AM Item ID: D3219-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Plate **Start Date:** 1/10/13 **Start Oty:** 60.00 *60* **Cust Item ID:** Required Date: 1/17/13 Rea'd Otv: 60.00 Customer: Reference: Run Process Plan: Date: Approvals: Tooling: Date: QC: ____ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject **Work Center ID** Description **Run Hours** Code Otv Otv 130 0.00 Small Fab *130* Small Fab 0.00 Memo Small Fab 1-Deburr if necessary. 140 QC5- Inspect part completeness to step on W/O 0.00 QC 0.00 Memo Quality Control

0.00

0.00

Identify as per dwg & Stock Location: WH

*** STOCK IN STEP CELL***

Memo

Reject

Number

Insp.

Stamp

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	AANCE / UP	DATE			_		
												QA Closed:	Da	te:	
Work Ord	er.					DISPOSITION				AGAINST [DE	PARTMENT	PROCESS		
						Rework			Skid-tube	Crosstube		_	Water Jet		Engineering
Part I	VO.			-		Scrap	1		Machining	Small Fab		1	d. Eng. Coor.	\square	Quality
NCR I	۷o.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	$\overline{}$	Other
Root					Descri	tion of work order update		nitial	Ac	ction		Sign &			
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng		cription		Date	Verificatio	n	QC Inspector
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Operator												·		į	
Material				!											
Setup													,	1	
Other				}											
Process															
Supplier															
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Unapproved															
						F.	AUL	T CATE	GORY						
Landi	ng (Gear				General		_		_		_			_
	L	Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete,	/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination	Г	Mainte	nance	Ī		Part Moved			_
		Heat Trea	t			Countersink		Mislabe	led	Ī		Positioned V	Vrong		
!		Inspection	n Strip in	Tube		Cut Too Short		Misread	I	Ī		Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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January-10-13 11:04:36 AM Item ID: D3219-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Plate **Start Date: Start Qty:** 60.00 *60* 1/10/13 **Cust Item ID:** Required Date: 1/17/13 Req'd Qty: 60.00 **Customer:** Reference: Run Start Process Plan: _____ Date: **Approvals:** Date: Tooling: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 160 QC21- Final Inspection - Work Order Release 0.00 *160*

0.00

Memo

Quality Control

QC

												DQA:	Date	•
NCR:	Yes	/ No					WORK ORDER NON-	COI	VFOR	MANCE / UPI	DATE		_	
							· · · · · · · · · · · · · · · · · · ·					QA Closed:	Date	:
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part	No.						Rework Scrap Use-as-is		Thern	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.						Work Order Update	ٔ ل		Large Fab	Composite]	Supplier	
Root					Des	crip	ption of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		C	r Non-conformance	Cł	nief Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator faterial etup ther rocess upplier raining napproved														
		L	·	i				FAUI	T CATE	GORY			L	
Land	ing (Gear					General							
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Torque Waves in Extrusion Drawing Turning Sequence Finish			-	4	Seguence								

Outside Dirnensions

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Wave/Twist in Tube

Picklist Print

January-10-13 11:04:42 AM

Work Order ID: 95514

D3219-1

Parent Item Name: Plate

95514

D3219-1

Start Date: 1/10/13

Required Date: 1/17/13

Start Qty: 60.00

Required Qty: 60.00

Comments:

Parent Item:

IPP A04.04.19New issueKJ/JLM ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6S.125		Purchased	No			100	sf	151.7162	0.0964	6.088421				
M6061T6	C 125								**	_			~	

M6061T6S 125 6061-T6 .125 Sheet

Location	Loc Qty	Loc Code	
MAT021	151.7161578		
121473	0.9161578		
123279	150.8		123279

Jm 13-1-21

NCR:	Yes /	No No				WORK ORDER NON-O	O	VFORM	JANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	er.					DISPOSITION			·	AGAINST DE	PARTMENT	/PROCESS	
Part No						Scrap Machi Use-as-is Thermoforn			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								·					
						F.	AUL	T CATE	GORY	· · · · · · · · · · · · · · · · · · ·			
Landi	B C C C C H	ar ending entre No racks rushed/C uffs eat Tream aspection	Crimped. t		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on incomplete ions incomplete/U inance iled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	l IR	innles in	Rend -		1	Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dirnensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE L	TD		Work Order:	95574
				,
Description: Plate			Part Number:	D3219-1
				-
Inspection Dwg: D3219	Rev: A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	L	_	L		3 1	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	0.317	_		V	Jimoi
2.293	+/-0.005	2.294"	-		ν	
2.965	+/-0.010	2.973"			ν	
0.566	+/-0.010	0572	-		V	
0.375	+/-0.010	0.376"	7		V	
R0.125	+/-0.010	6,125	_		RG	
13.9°	+/-0.5°	13.90	_		RG-	
				·	3	
						,
·	·					
	·					
						-
				8.0		

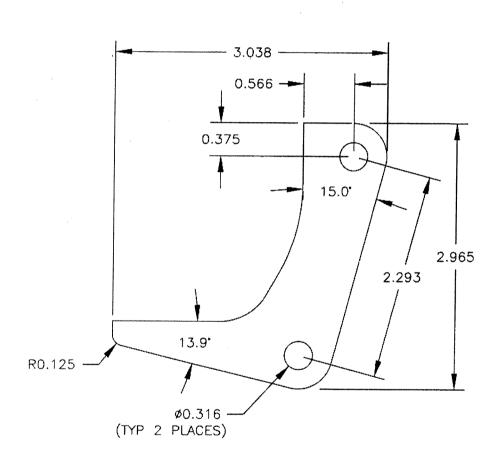
Measured by: Jm	Audited by:	15 9-83	Prototype Approval:	N/A
Date: \3-1-21	Date:	13121	Date:	N/A

Revised by	Approved
KJ/JLM	
KJ/JLM	
KJ/DD ax	1/2
	KJ/JLM KJ/JLM





DESIGN	DRAWN BY	DART AERO HAWKESBURY, OI	
CHECKED	APPROVED.	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE		TITLE	SCALE
03.10.10		PLATE	1:1
Α .	03 10 10	NEW ISSUE	



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
- (REF DART SPEC M6061T6S.125)
- FINISH: NONE
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED-0
- 6) ALL DIMENSIONS ARE IN INCHES

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